



Dart Aerospace Ltd.
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D3681-1

Job Sheet 181688



Part No: D3681-1

Job Qty: 60 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/4/18

Job Tracking No:

Due Date: 8/24/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev A new issue 07-10-30 DD verified by:EC IPP Rev:B Ecn 1056 Rev A dwg DD IPP Rev:C
add seq 125 DD 10.05.03 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea	8/24/18	8/24/18	0.00	0.00	Start Up Machining-2		JBD 15/10/06
100	Hardinge	60 pcs	8/24/18	8/24/18	0.06	1.59	Hardinge		OK 18/10/09
120	QC	60 pcs	8/24/18	8/24/18	0.00	0.00	QC8		BE
125	Skidtubes	60 pcs	8/24/18	8/24/18	0.00	0.43	Skidtubes-2		BE
130	Packaging	60 pcs	8/24/18	8/24/18	0.00	0.00	Packaging3-1		
140	QC21-SA	60 Ea	8/24/18	8/24/18	0.00	0.00	QC21		

Part Op 100 - 1-TURN AS PER FOLIO FA711& DWG D3681

Descriptions: 125 - 1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

130 - ***STOCK IN SKIDTUBE CELL***

DAS
21
9-05
OCT 17 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.3125W.058	Aluminum Tube .3125 X .058W	20.4000 ft (.34 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T0.3125W.058	20	187	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.313inches $\pm$ 0.010	0.323 0.303		
2	Spacer	0.197inches $\pm$ 0.010	0.207 0.187		
3	Spacer	4.080inches + 0.030 - 0.000	4.110 4.080		
4	Spacer	0.025inches $\pm$ 0.010	0.035 0.015		
5	Spacer	45.0Degrees $\pm$ 0.5	45.5 44.5		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Quality ☐ Other ☐																															
Date : _____		Step #: _____		MRB (QSI042) Approval																															
Description Work Order								Completed By																											
1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 10/07/19 Container No: S116457 Part: D3681 - 1 Job No: 181688 Serial No/Batch: S116457 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's								Lead hand / Supervisor Approval Verification																											
DART AEROSPACE <table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="2">Root Cause</th> </tr> </thead> <tbody> <tr><td>Environment</td><td>☐ No Re-verification</td></tr> <tr><td>Design</td><td>☐ Operator</td></tr> <tr><td>Doc/Data</td><td>☐ Offset/Setup</td></tr> <tr><td>Equip/Tooling</td><td>☐ Supplier</td></tr> <tr><td>Handling/Pre</td><td>☐ Training</td></tr> <tr><td>Material</td><td>☐ Use for Testing</td></tr> <tr><td>Internal Transport</td><td>☐ Poor Information</td></tr> <tr><td>Tribal Knowledge</td><td>☐ Rushing</td></tr> <tr><td>LOA</td><td>☐ Product Improvement</td></tr> <tr><td>Substation</td><td>☐ Process Improvement</td></tr> <tr><td>Past Expiry Date</td><td>☐ Manufacturing Process</td></tr> <tr><td>Misidentified</td><td>☐ Past Due</td></tr> </tbody> </table>								Root Cause		Environment	☐ No Re-verification	Design	☐ Operator	Doc/Data	☐ Offset/Setup	Equip/Tooling	☐ Supplier	Handling/Pre	☐ Training	Material	☐ Use for Testing	Internal Transport	☐ Poor Information	Tribal Knowledge	☐ Rushing	LOA	☐ Product Improvement	Substation	☐ Process Improvement	Past Expiry Date	☐ Manufacturing Process	Misidentified	☐ Past Due	QC / QA Coordinator Approval	
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☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Bore/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center								☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence																											
OTHER : _____																																			